

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003410**Date Inspected:** 10-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yanhua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

New Tower Shop Bay 1:

The QA Inspector performed Visual Inspection (VT) prior to weld repairs in conjunction with ZPMC and ABF QC on the welds attaching U-Ribs to Deck Plate DP079-001 at Weld Joint (WJ) Numbers 001 through 010. The QA Inspector signed off for initial VT prior to repairs after sign off by ZPMC and ABF QC on Tag Number 000118. The attached photographs provide additional detail.

The QA Inspector randomly observed ZPMC welder Hu Yong Cang ID Number 023805, utilizing the Flux Cored Arc Welding (FCAW) Process with ZPMC Weld Procedure Specification (WPS)

WPS-345-FCAW-2G(2F)-Repair-1, to perform weld repairs to areas marked off by ZPMC QC on the welds attaching U-Ribs to Deck Plate DP076-001 Tag Number 0000000116 at WJ's 001 through 010. The QA Inspector randomly observed ZPMC CWI Li Yanhua monitoring weld parameters. The QA Inspector randomly verified the weld parameters and recorded them as follows: 290 amps, 29.2 volts with a travel speed of 525 millimeters (mm) per minute. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

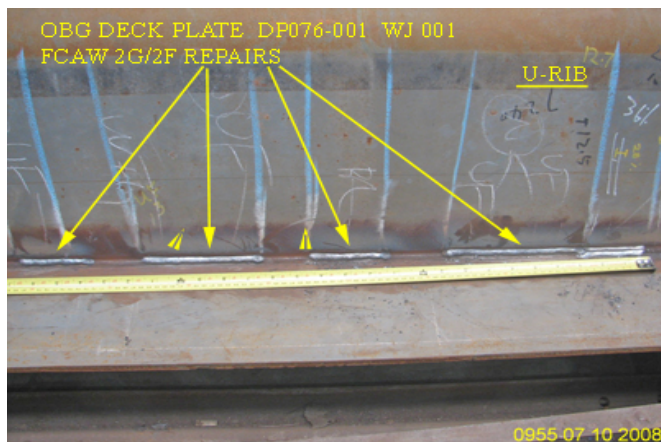
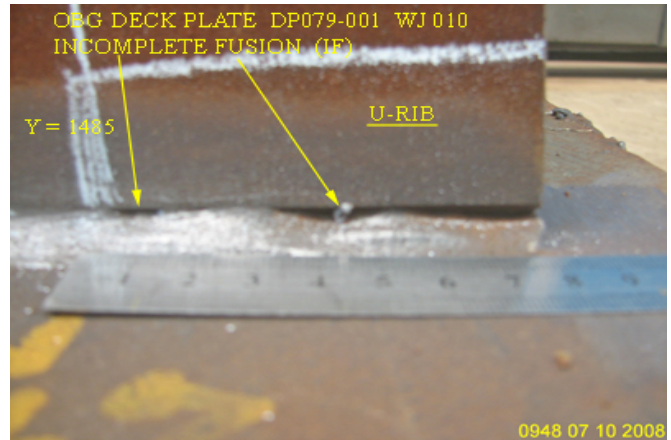
The QA Inspector randomly observed ZPMC helpers utilizing grinders to blend the reinforcing fillet welds on Deck Plate DP066-001 Tag Number 0000000114 after repairs, at WJ's DP066-001-001 through 010.

WELDING INSPECTION REPORT

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The QA Inspector randomly observed ZPMC helpers utilizing grinders to prepare marked up areas for weld repair and blend the reinforcing fillet welds on Deck Plate DP066-001 Tag Number 000000114 prior to repairs, at WJ's DP066-001-001 through 010.

SFOBB QA VERIFICATION TAG IN-PROCESS			
SUBASSEMBLY DP079-001			Tag No. 000118
INSPECTIONS		REPAIRS	
	ZPMC	ABF	CT
FVT			
UT			
MT			
RT			
Dimen.			
Notes: <input type="checkbox"/> ZPMC <input type="checkbox"/> ABF <input type="checkbox"/> CT			
SIGN OFF PRIOR TO REPAIRS			
1004 07 10 2008			



Summary of Conversations:

There were no relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer